

Date: Friday, 01/02/2008 8:56:48 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INBOARD WINDOW DOUBLER
 Job Number : 37133
 Estimate Number : 13147
 P.O. Number :
 This Issue : 01/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 08-01-30 new issue DD verified by:

Part Number : D37001
 Drawing Number : D3700 U/R
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 08/02/2008 Qty: 2 Um: Each

PROTOTYPE

Additional Product

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.2984 sf(s)/Unit Total: 0.5968 sf(s)
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)
 Batch: *106350 IB 8-1-2*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3700 *IB 8-1-2*
 Dwg Rev: *U/R*
 Prog Rev: *U/R*
 2- Deburr if necessary *IB 8-1-2*

(2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

IB 08-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/02/2008 8:56:48 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INBOARD WINDOW DOUBLER

Job Number: 37133

Part Number: D37001

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Bob 02-20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

D20 Stow

Bob 02-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D081 05/21

Job Completion



FOR ENGINEERING USE ONLY

POSITIVE RECALL

EFFECTIVE *08-02-01* AUTH *DL*

RELEASED _____ DATE _____

MF 08-05-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.



Product #: D412-761

Job #: 00224A

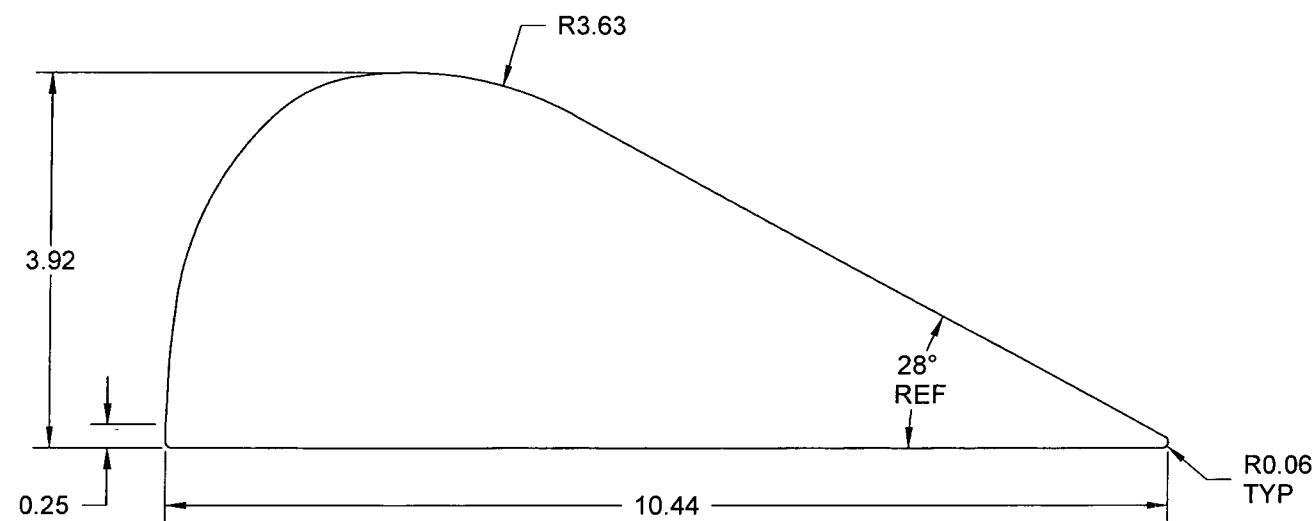
Date: 08.01.31

Product Name: VERTICAL REFERENCE DOOR

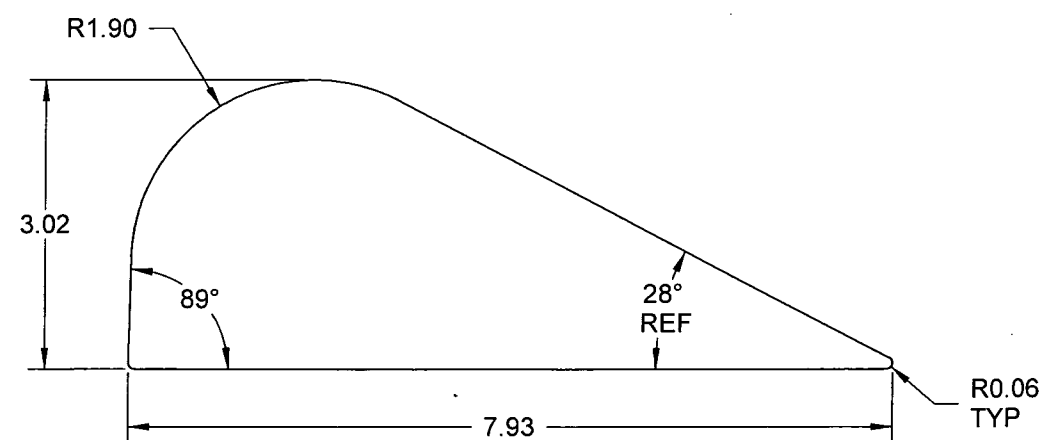
Requested By: MB

Design Manager Approval: [Signature]

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3700-1	INBOARD WINDOW DOUBLER	08.01.29	YES	ASAP	SEE BELOW	
2	D3700-3	OUTBOARD WINDOW DOUBLER	08.01.29	YES	ASAP	SEE BELOW	
2	D3701-1F	(FLOOR DOUBLER) FLAT PATTERN	08.01.29	YES	ASAP	SEE BELOW	
2	D3702-1	FORWARD DOUBLER	08.01.30	YES	ASAP	MAKE ONE WITH HOLES/SLOT + ONE WITHOUT HOLES/SLOT + SEE BELOW.	
2	D3703-1	AFT DOUBLER	08.01.30	YES	ASAP	SEE BELOW	
						HAND ALL W/Os AND PARTS TO DAN STOW	



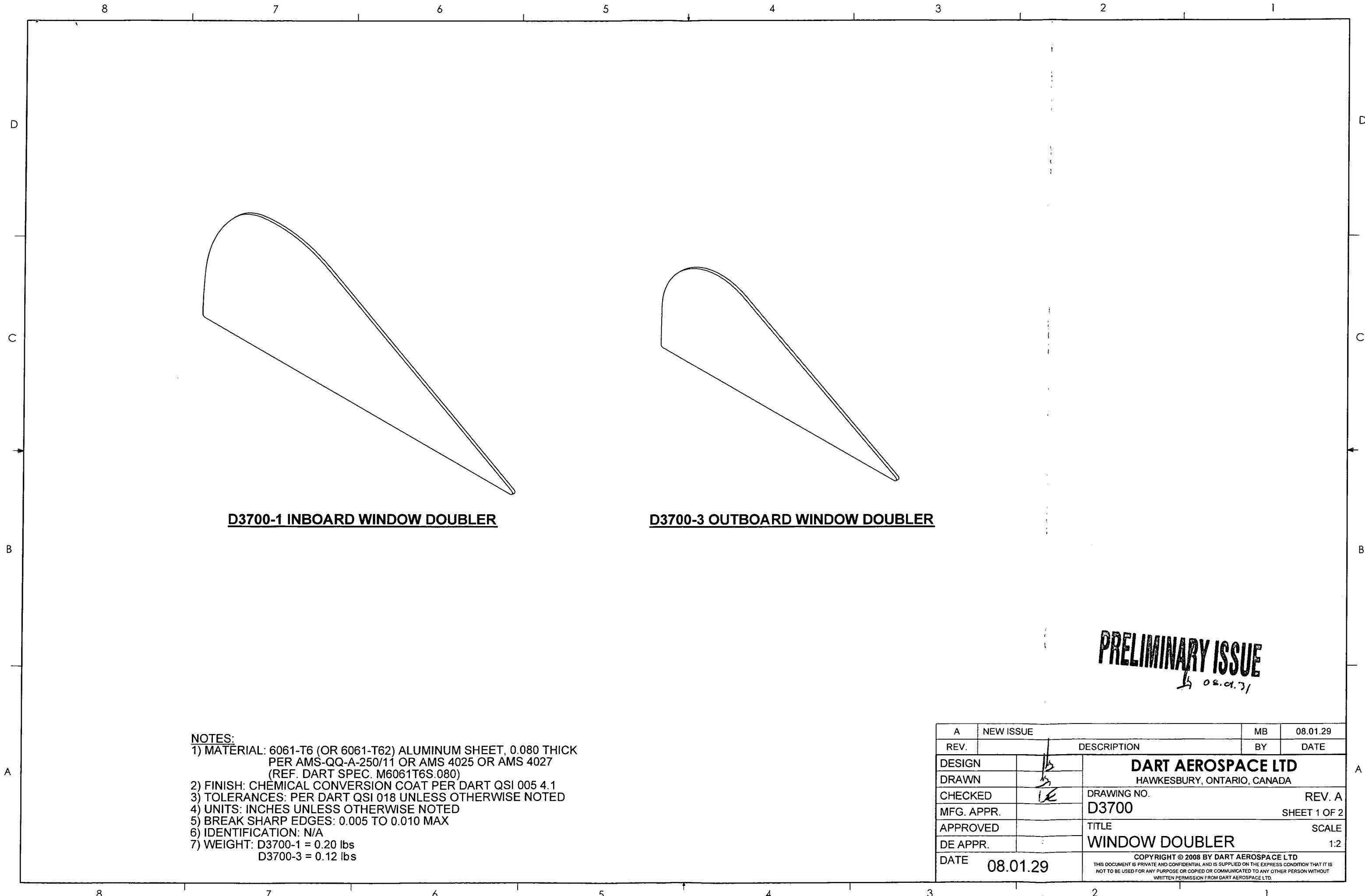
D3700-1 INBOARD WINDOW DOUBLER



D3700-3 OUTBOARD WINDOW DOUBLER

PRELIMINARY ISSUE
08-01.21

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3700	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	1:2
DATE	08.01.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3700-1 INBOARD WINDOW DOUBLER

D3700-3 OUTBOARD WINDOW DOUBLER

PRELIMINARY ISSUE
H 08.01.29

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3700-1 = 0.20 lbs
D3700-3 = 0.12 lbs

A	NEW ISSUE		MB	08.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3700	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.			WINDOW DOUBLER	1:2
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